

APR 20 2018

APR 16 2018

May 8 11B



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

002893

D412-698-012
Job Sheet 175493



Part No: D412-698-012

Job Qty: 2 ea

Part Name: Cabin Door Roller RH Aluminum Door



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 4/5/18

Job Tracking No:

Due Date: 5/8/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: IIN-D412-698 REV.G IPP Rev:C 04.02.26 Change Qty of D3121-141 & remove D3121-145 from Step 1,3
KJ/DS IPP Rev:D 08-01-28 change to rev D ECN 1104 DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	2 Ea	5/8/18	5/8/18	0.00	0.00	Start Up Stores/Pkg-2		
110	Packaging	2 pcs	5/8/18	5/8/18	0.00	0.00	Packaging1-4		
120	QC	2 pcs	5/8/18	5/8/18	0.00	0.00	QC4		
125	DC	2 pcs	5/8/18	5/8/18	0.00	0.00	DC		
130	Packaging	2 pcs	5/8/18	5/8/18	0.00	0.00	Packaging3-2		
140	QC21-FG	2 Ea	5/8/18	5/8/18	0.00	0.00	QC21		

Part Op 125 - Photocopy bluefile and create labels per PPP D412-698-012 CHG003
Descriptions: 130 - Identify and pack for shipping as per PPP D412-698-012 Location : FG034

DAS
21
9-89

24/28/2018
MAY 10 2018
DAS
58
9-89
MAY 10 2017
MAY 11 2018

fg039

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D3121-141	Bracket Assembly	6 Ea (3 ea)	90-Start up Operation	5024392
D3121-144	Bracket Assembly	2 Ea (1 ea)	90-Start up Operation	5019550
D3137-043	Bracket Assembly	2 Ea (1 ea)	90-Start up Operation	F148252
D3183-044	Bracket Assembly	2 Ea (1 ea)	90-Start up Operation	F149523
D3199-1	Bracket	18 Ea (9 ea)	90-Start up Operation	5034282x9
D3202-1	Cover	2 Ea (1 ea)	90-Start up Operation	5009143x1

50681005

5034282x9

5063076x

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D3121-141	6	1	0
	D3121-144	2	2	0
	D3137-043	2	4	0
	D3183-044	2	2	0
	D3199-1	18	13	0
	D3202-1	2	11	0

Part Specifications

Specifications could not be found.

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation			Disposition		
			Completed By		
			Supervisor		
			Signature		
			Date		
Root Cause			FAULT CATEGORY		
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Lo: ☐	
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Progr ☐	
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stc ☐	
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Seq ☐	
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned ☐	
Past Expiry Date ☐	Manufacturing Process ☐				
Misidentified ☐	Past Due ☐	OTHER :			

Container No: S070106
 Part: D412-698-012
 Job No: 175493
 Serial No/Batch: S070106
 Revision: G
 Inspector: _____

Date: 05/10/18
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6.0 PARTS LIST – CABIN DOOR MODIFICATION KITS

(FOR AIRCRAFT EQUIPPED WITH P/N 205-032-669-XXX ALUMINUM DOORS)

Qty -011	Qty -012	Qty -013	Qty -017	Qty -019	Qty -021	Qty -027	Qty -028	Part Number	Description
X								D412-698-011	CABIN DOOR ROLLER KIT, LH
	X							D412-698-012	CABIN DOOR ROLLER KIT, RH
		X						D412-698-013	DOOR HANDLE KIT
			X					D412-698-017	REPLACEMENT DOOR TRACK KIT
				X				D412-698-019	BEARING OVERHAUL KIT
					X			D412-698-021	REPLACEMENT SHIM KIT
						X		D412-689-027	BRACKET KIT, LH (ALUMINUM DOORS)
							X	D412-689-028	BRACKET KIT, RH (ALUMINUM DOORS)
3	3							D3121-141	BRACKET ASSEMBLY
1								D3121-143	BRACKET ASSEMBLY
	1							D3121-144	BRACKET ASSEMBLY
1	1							D3137-043	BRACKET ASSEMBLY
1								D3183-043	BRACKET ASSEMBLY
	1							D3183-044	BRACKET ASSEMBLY
9	9		9					D3199-1	BRACKET
						1		D3199-3	FORWARD BRACKET, LH
							1	D3199-4	FORWARD BRACKET, RH
1	1		1					D3202-1	COVER
		4						D3203-1	HANDLE
		1						D3220-041	DOUBLER
		1						D3220-042	DOUBLER
		2						D3220-3	DOUBLER
				7				D3121-21	BOLT
				5				D3121-241	BEARING ASSEMBLY
				1				D3137-3	GUIDE
				1				D3137-5	WASHER
				2				D3183-045	BEARING ASSEMBLY
					3			D3238-1	SHIM
					1			D3238-3	SHIM
					2			D3238-5	SHIM
					6			D3238-11	SHIM
					2			D3238-13	SHIM
					4			D3238-15	SHIM
		8						NAS1149D0463J	WASHER (AN960JD416L)
		8						MS21042L4	NUT (OR MS21042-4)
		16						MS24694-S98	SCREW
				1				MS24694-S101	SCREW

Change Record

PAGE 1 OF 1

Part Number: D412-698-011/-012

Description: CABIN DOOR ROLLER, LH/RH

[illegible]